

Date: Thursday, 2/7/2008 10:54:20 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	37282					
Estimate Number	10530					
P.O. Number	:		Part Number	D2571		
This Issue	2/7/2008	S.O. No. :	Drawing Number	D2571 REV E		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	E		
Previous Run	36322		Material	:		
Written By	:	<i>JK</i>	Due Date	2/28/2008	Qty:	12 Um: Each.
Checked & Approved By	<i>JK 08/02/07</i>					
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <i>JK 34875</i>	<i>JK 08/02/26</i> 12
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>JK</i> Double check by: <i>JK</i> <i>34875</i> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>JK/SD 08/03/01</i> 12
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	<i>JK/SD 08/03/01</i> 22
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>JK/SD 08/03/01</i> 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod / Machines / Part NCR: Yes No DQA: D Date: 08/03/06
 QA: N/C Closed: Y Date: 08/03/06

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/27	2	WALL THICKNESS ON SKIDTUBE IS 0.111 INSTEAD OF 0.125". THICKNESS AT SKIDTUBE RIDGE IS 0.301" IN SPOTS.	IP 08.02.27 per 081042	SCRAP PART, REPLACE.	Amk 08/03/01	/	IP 08.02.27 per 081042	/
		R.C. operator error.						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number: 37282		Part Number: D2571	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK		SP 08-03-03 (12)	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 	
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		BR 08-03-03 (12)	
7.0	POWDER COATING	POWDER COATING 	
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		FD 08/03/04 (12)	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 	
Comment: INSPECT POWDER COAT 		M-1 m-1 08/03/04 (12)	
9.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 438		8/3/5 50 (12)	
10.0	QC21	FINAL INSPECTION/W/O RELEASE 	
Comment: FINAL INSPECTION/W/O RELEASE		12/08/08/06 (12)	
Job Completion 		2008/3/05 (12)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD				Work Order:	37282
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.006	8.007	8.005		
F	0.490	0.510		.508	.497	.500	.508		
G	0.257	0.262	DT8683	0.259	0.260	0.260	0.260		
H	0.375	0.380	DT8684	.377	0.377	0.377	.377		
I	0.490	0.510		.501	0.501	0.500	.501		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		.566	0.566	0.568	.567		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.496	1.496	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.122	0.124	0.127	.126		
Q	0.115	0.135		.135	0.135	0.135	.135		
R	0.240	0.260		.250	0.253	0.253	.253		
S	0.115	0.135		.132	0.135	0.133	.133		
T	0.178	0.198		.188	0.188	0.188	.188		
U	2.940	2.980		2.959	2.956	2.960	2.960		
V	0.230	0.250		.241	0.243	0.238	.242		
W	0.115	0.135		.120	0.131	0.127	.127		
X	0.308	0.313		.309	.308	.310	.310		
Y	0.760	0.765		.760	.762	.762	.762		
Z	0.352	0.372		.362	.362	.365	.362		
AA	0.470	0.530		.500	0.500	0.500	.500		
AB	0.615	0.635		.634	.623	.633	.633		
AC	0.053	0.073		.063	0.063	0.063	.063		
AD	0.240	0.260		.246	0.251	0.247	.247		
AE	1.375	1.395		1.388	1.385	1.390	1.388		
AF	0.115	0.135		.133	0.133	0.133	.135		
AG	0.240	0.280		.251	0.260	0.255	.255		
AH	0.240	0.260		.246	0.253	0.248	.253		
AI	2.000	2.020		2.002	2.000	2.003	2.004		
AJ	0.023	0.043		.037	0.030	.030	.030		
Accept/Reject									

Measured by:	OMR / SA	Audited by:	BC
Date:	08/02/28	Date:	08/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA

1-382
1-626

2-166 8/11

DART AEROSPACE LTD		Work Order:	37282
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.442	.442	.442	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.002	8.002		
F	0.490	0.510		.493	.493	.493	.493		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.497	.495	.495	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.570	.570	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.493	1.493	1.493		
N	2.495	2.505		2.498	2.499	2.499	2.499		
O	3.869	3.879		3.674	3.674	3.674	3.674		
P	0.115	0.135		.127	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.234	.253	.252		
S	0.115	0.135		.133	.130	.131	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.241	.241	.241		
W	0.115	0.135		.131	.132	.132	.123		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.762	.762	.766	.766		
Z	0.352	0.372		.361	.362	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.629	.629	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.258	.260	.260	.260		
AE	1.375	1.395		1.390	1.390	1.389	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.255	.255	.255		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.003	2.003	2.003	2.002		
AJ	0.023	0.043		.030	.030	.033	.033		

Accept/Reject

Measured by: *SA*
Date: 08/02/28

Audited by: *PC*
Date: 08-03-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SA</i>

SA

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B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.506	3.506	3.506	3.506		
D	1.745	1.755		1.756	1.756	1.749	1.756		
E	7.990	8.010		8.002	8.000	8.000	8.006		
F	0.490	0.510		1.502	.501	.501	.509		
G	0.257	0.262	DT8683	1.258	1.260	1.259	1.259		
H	0.375	0.380	DT8684	1.377	1.378	1.378	1.377		
I	0.490	0.510		.506	.506	0.506	.506		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.576	.578	0.578	.576		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.493	1.493		
N	2.495	2.505		2.506	2.506	2.506	2.500		
O	3.869	3.879		3.871	3.871	3.873	3.872		
P	0.115	0.135		0.125	.127	0.128	.126		
Q	0.115	0.135		0.135	.135	0.135	.135		
R	0.240	0.260		0.250	.253	0.253	.252		
S	0.115	0.135		0.130	.133	0.130	.134		
T	0.178	0.198		0.188	.188	0.188	.188		
U	2.940	2.980		2.958	2.958	2.958	2.958		
V	0.230	0.250		0.234	.247	0.238	.248		
W	0.115	0.135		0.126	.127	0.118	.130		
X	0.308	0.313		.369	.309	.309	.309		
Y	0.760	0.765		.766	.766	.766	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.506	.500	.506		
AB	0.615	0.635		.632	.632	.628	.630		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		.246	.257	0.247	.257		
AE	1.375	1.395		1.392	1.391	1.391	1.382		
AF	0.115	0.135		.133	.133	0.135	.135		
AG	0.240	0.280		.257	.257	0.266	.260		
AH	0.240	0.260		0.249	0.256	0.248	.256		
AI	2.000	2.020		2.005	2.007	2.007	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>JLM</i>
Date:	08/03/01

Audited by:	<i>BC</i>
Date:	05.03.03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JLM</i>	<i>JLM</i>





